Date:

Monday, 09/03/2009 1:41:58 PM

User:

Julie Dawson

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Job Number

: 46325

Estimate Number

: 10823

P.O. Number This Issue

: 09/03/2009

: NC

Prsht Rev. First Issue : //

: 40390 **Previous Run**

Written By

Checked & Approved By Comment

: Est. D 05.11.02

Est Rev:E

Type

Removed 303SS

: MACHINED PARTS

Removed 303 SS KJ/EC JLM **Drawing Name**

Part Number

: D23271 : D2327 REV D

: SPACER BUSHING

Drawing Number Project Number

: N/A : D

Drawing Revision

Material **Due Date**

: 20/03/2009

Qtv:

Additional Product

Job Number:



Seq. #:

1.0

2.0

Machine Or Operation:

M304R0375

Description:

304 ROUND BAR 0.375

Comment: Qty.:

0.1860 f(s)/Unit Total: 9.2978 f(s)

Batch:

M110472

* no more ma

(M304R0.375)

Inventory

HARDINGE

Comment: HARDINGE CNC LATHE SMALL

Turn per Folio FA232 and Dwg D2327

Material: AISI 304 Round Bar Ø0.375"

Deburr

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Fewe Basket Cell

Dart Aerospace Ltd

| W/O: | | | WC | RK ORDER CHANG | ES | | | | | |
|---------|------|-------------------|---|------------------------------|---------|----------------|-------|-----|-------------------------------|--------------------------|
| DATE | STEP | PR | OCEDURE CHA | NGE | | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | | |
| | | | | | | | | | | } |
| | | | | | | | | | | |
| Part No | | PAR #: | | | | | | | | |
| | Res | olution: | Disposition | າ: | _ QA: N | VC Clo | sed: | | Date: | |
| NCR: | | | WORK ORDI | ER NON-CONFORMA | NCE (| (NCR) |) | | | |
| DATE | STEP | Description of NC | Description of NC Corrective Action Section | | | Varities | | | tion Approval | Approval |
| | | Section A | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | Secti | | Chief Eng | QC Inspector |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | <u>.</u> | | | | |
| | | | | | | | | | | |
| | | | | | | | | : | | |

NOTE: Date & initial all entries

Date:

Monday, 09/03/2009 1:41:58 PM

User:

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BUSHING

Job Number: 46325

Part Number: D23271

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-03-11

Dart Aerospace Ltd

| W/O: | | | WC | RK ORDER CHANG | GES | | | | | |
|---------|------|---------------------------------|-----------------------------|---|---------|--------------|-----------|----------|-------------------------------|--------------------------|
| DATE | STEP | PRO | OCEDURE CHANGE | | | , | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| Part No | • | PAR #: | Fault Cate | gory: | NCR: Y | es N | o DQA | | Date: | |
| | | | Disposition: QA: N | | | | | | | |
| NCR: | | | WORK ORDE | R NON-CONFORM | ANCE (N | CR) | | | <i>y</i> | |
| DATE | STEP | TEP Description of NC Section A | Corrective Action Section B | | | Verification | | Approval | Approval | |
| | SILI | | Initial Chief Eng | Action Description Chief Eng | | gn & ate | Section C | | Chief Eng | QC Inspector |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | 10 - 10 - 10 - 10 - 10 - 10 - 10 - 10 - | | | | | , . | |
| | | | | | | | | | | |
| | | | | | | | | | | |
| | | | | | | | | <u>-</u> | | |
| | | | | | | | | | | |
| | | | | | | | | | | |

NOTE: Date & initial all entries

| DART AEROSPACE LTD | Work Order: 44325 |
|------------------------------|----------------------|
| Description: Spacer Bushing | Part Number: D2327-1 |
| Inspection Dwg: D2327 Rev: D | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| | | X First Art | icle | Prot | otype | |
|----------------------|---------------|---------------------|--------|--------|-------------------------|----------|
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
| Ø0.375 | +/-0.010 | 0,374 | | | | |
| Ø0.257 | +0.005/-0.000 | 0,238 | | | | |
| 2.000 | +/-0.010 | 2034 | | | | |
| | | | | - | | |
| | | | | | | |
| | | | | _ | | |
| | | | | | | |
| | | | | | | |
| | | | | | | · |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

| Measured by: | Audited by: | Prototype Approval: | N/A |
|----------------|----------------|---------------------|-----|
| Date: 09/03/10 | Date: 09/03/10 | Date: | N/A |

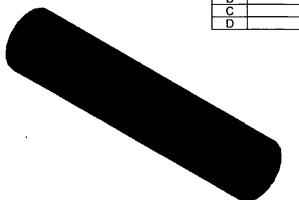
| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------------------|------------|----------|
| Α | 03.11.27 | New Issue | KJ/RF | |
| В | 06.11.24 | Dwg Revision revised | KJ/JLM | |
| С | 08.02.01 | Tolerance revised for Ø0.375 | KJ/EC/DD | - 78- |

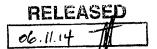


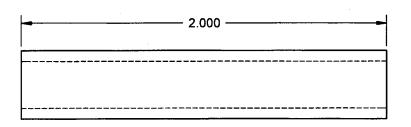
| DESIGN BW | DRAWN BY | | OSPACE LTD ONTARIO, CANADA |
|--------------|----------|-------------|-------------------------------|
| CHECKED | APPROVED | DRAWING NO. | REV. D |
| CE | 99 | D2327 | SHEET 1 OF 1 |
| DATE | | TITLE | SCALE |

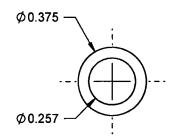
| i i | 00.10.12 | OF AGENT BOOKING |
|-----|----------|------------------------|
| REV | DATE | DESCRIPTION |
| Α | 94.12.17 | NEWISSUE |
| В | 95.12.06 | LENGTH CHANGE |
| С | 03.05.13 | 303 SS SPEC ADDED |
| D | 06.10.12 | REMOVE 303 SS MATERIAL |

SPACER BUSHING



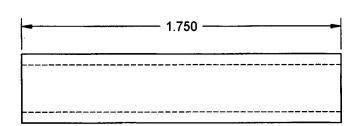


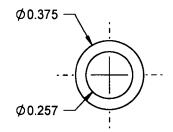




D2327-1 SPACER BUSHING

06 10 12





D2327-3 SPACER BUSHING

SHOP COPY

RETURN TO

NOTES ENGINEERING 1) MATERIAL: AISI 304/316 SS, Ø0.375, 0.065 WALL SEAMLESS ROUND TUBING ENGINEERING (REF. DART SPEC M304TR0.375W.065)

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP CORNERS TO 0.010 MAX

SUBJECT TO AMENDMENT WITHOUT NOTICE

WORK ORDER

COPYRIGHT © 1994 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.